

**Claims**

1. Drive roller for a textile machine producing cross-wound bobbins for the frictional drive of a cross-wound bobbin held so as to rotate in a creel of a winding device, characterised in that the outer periphery (21) of the drive roller (11) is formed by a thin-walled metal tube (19) profiled by high-pressure internal forming.
2. Drive roller according to claim 1, characterised in that the thin-walled, profiled metal tube (19) consists of steel, preferably a stainless high-grade steel alloy.
3. Drive roller according to claim 1, characterised in that the thin-walled profiled metal tube (19) is configured as a coated metal sleeve.
4. Drive roller according to claim 1, characterised in that the drive roller (11) is acted upon by an electric motor single drive in the form of external rotor (22), on the rotor housing (28) of which the thin-walled, profiled metal tube (19) is fixed.
5. Drive roller according to claim 1, characterised in that the thin-walled, profiled metal tube (19) has a wall thickness between 0.1 mm and 0.4 mm, preferably 0.2 mm.
6. Drive roller according to any one of the preceding claims, characterised in that the thin-walled, profiled metal tube (19) has a profiling that is stepped at least in the direction of rotation (R) of the drive roller (11), for example in the form of nubs (20) and/or webs (30).

7. Drive roller according to claim 6, characterised in that the nubs (20) extend over the central region (31) of the drive roller (11), while webs (30) are arranged in the side regions (32, 33).

8. Drive roller according to claim 6, characterised in that the drive roller (11) has webs (30) in its central region (31).

9. Drive roller according to claim 6, characterised in that the nubs (20) extend uniformly over the entire outer periphery of the thin-walled, profiled steel tube (19).